Work Orde Tuesday, March						<u>-</u> -						Page 1
Item ID: Revision ID: Item Name:	D3211-1 Bracket			Accept				s s	Setup S	Start Stop	1 /8811181 81	
Start Date: Required Date: Reference:	3/28/2011 4/1/2011	Start Qty: 6.00 Req'd Qty: 6.00			Cust Item Customer:	ID:						41 4 11 8 11 8 1 1881
Approvals:	Process Plan	n:	Date: //03-77	Tooling: SPC (Y/N):		ate:		F		Start Stop		
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr	·									•
D3211	Rev	A1 / DEO										
		FLOW WATER JET		0.00				m .	7 70			
Waterjet FLOW CNC Waterj	et 		per Dwg D3211 Dwg Revalencessary	0.00 A\ □Prog Rev:_	<u>A</u> \ ii2-			tts.tt.	<u> 3-30</u>		- (Z	<u> </u>
		QC2- Inspect parts of	f machine FAI/FAIB	0.00								
1 1 1 1 1 1 1 1 1 1		Memo		0.00				HB 11-	3-36			

QC8- Inspect parts - second check

Quality Control

Memo

0.00 (03/30

Dart	Aeros	pace	Ltd
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Dail Aerospace Liu							•	
W/O:			WORK ORDER	CHANGES				
DATE	STEP	PROCEDU	RE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							¥	
Part No	:	PAR #: Fa	nult Category:	NCR: Yes	No DQ	A:	Date: _	
	Reso	olution: Di	sposition:	QA: N/C C	losed:		Date: _	

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC			Corrective Action Section B	Verification	Approval	Approval
DATE	STEP	Section A Initial Chief Eng		Action Description Sign Chief Eng Date	& Section C	Chief Eng	QC Inspector	
							1	
	:							

Work Order ID 67641

Tuesday, March 29, 2011 8:23:36 AM



Page 2

Item ID:

D3211-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Bracket

Required Date: 4/1/2011

3/28/2011

Start Qty: 6.00

Req'd Qty: 6.00



Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



Date: _____

SPC (Y/N):

Date:

Tool#

Plan

Code

Stop

Reject

Qty

Accept

Qty



Number Stamp

Insp.

Reject

Sequence ID/ **Work Center ID**

130

Small Fab Small Fab

Operation Description

Small Fab

Memo

Deburr

Set Up/ **Run Hours**

0.00

0.00

NA

140

Brake NC Brake NC

NC BRAKE

Memo

Memo

Bend D3211-1 Stack as per Dwg D3211

0.00

0.00

SD 11/03/30

150

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00 8 403/30

W/O:		WORK ORDER CI	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				

Part No: $D3211-)$	PAR #:	Fault Category:	Small Flots	NCR: (es No	DQA:	Date: //W/-05
Resolution: _	SCVW	Disposition:	SCVAD	QA: N/C Closed	d: () ()	Date: 1104/07

NCR: 6	7641	W	ORK	OR	DER NON-CONFORMANCI	E (NCR)			('			
DATE	STEP	Description of NC			Corrective Action Section B	Sign 2	Verification	Approval	Approval			
	J.L.	J.L.	J.L.	3121	Section A	Initi Chief I		Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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11/03/30	140	Section A I piece crack at the bend		1		11/03/30						
110-315		l.C.	Jose	un	Scrap distrey	, ,	S 120	posiun	/1103-30			
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Work Order ID 67641

Tuesday, March 29, 2011 8:23:36 AM



Page 3

Item ID:

D3211-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Start Date: 3/28/2011 Required Date: 4/1/2011

Start Qty: 6.00

Req'd Qty: 6.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

160

HandFinish Hand Finishing Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty Qty

Reject Reject

Insp. Number Stamp

170

Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M 115178

Memo

0.00

OVEN TEMPERATURE:

180

QC3- Inspect Part Finish

0.00

Memo

0.00

6 Bl 11-3-31

Quality Control

Dart Aerospace Ltd WORK ORDER CHANGES W/O: Approval **Approval** DATE STEP PROCEDURE CHANGE Qtv Chief Eng / Prod Mgr Bv Date QC Inspector Part No: ______ PAR #: _____ Fault Category: ______ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		'	WORK	ORDI	ER NON-CONFORMANC	E (NCR)			
	T	Description of NC			Corrective Action Section B		Verification	Approval	Approval QC Inspector
DATE	STEP	Section A Initi	Initi Chief		Action Description Chief Eng	Sign & Date	Section C	Chief Eng	
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-									
NOTE: D	ate & initia	I all entries							<u> </u>

Work Order ID 67641

Tuesday, March 29, 2011 8:23:36 AM



Page 4

Item ID:

D3211-1

Accept



Setup Start

Run



Revision ID:

Start Date:

Item Name:

Bracket

3/28/2011

Start Qty: 6.00

Req'd Otv: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Start

Stop

Stop

Sequence ID/

Required Date: 4/1/2011

Work Center ID

190

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: 211

Date:

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Oty

Reject Insp. Stamp Number

200

OC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

Dart	Aeros	pace	Ltd
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W/O:			WO	WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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DATE	STED	Description of NC Section A	<u> </u>		ion B	Verification	Approval Chief Eng	Approval QC Inspector					
	J		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C							
					,			·					

Status

Tuesday, March 29, 2011 8:23:42 AM

Work Order ID: 67641

Parent Item:

D3211-1

Parent Item Name: Bracket



Start Date: 3/28/2011

Required Date: 4/1/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A IPP Rev:B

New Issue

05-11-17 JLM Now on Waterjet 06-10-24 JLM

Component Item	ID/
Item Name	

Replacement Mfg/ Item ID

Purch

Bin Primary Item Location

- Location

No

Last Location

Route Seq ID

100

Unit of Measure Hand

sf

5

4

48

Loc Qty

Qty on

57.0000

Loc Code

Qty per Kit Total

Qty 8.873684 Issued

Date

M2024T3S.063

Purchased

2024-T3 .063 sheet

MAT022 57 113867 114351

117018

1.405

B11-3-30

Qty

Issued

Dart Aerospace Ltd

W/O:			V	VORK ORDER CHANG	iES			
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mar	Approval QC Inspector
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NCR:			WORK OR	DER NON-CONFORM	ANCE (NCR))		
DATE	OTED	Description of NC			tion B	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		
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DART AEROSPACE LTD	Work Order:	47641
Description: Bracket	Part Number:	D3211-1
Inspection Dwg: D3211 Rev: A1		Page 1 of 1

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Dart Aerospace

	WORK ORDER CHANGES										
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	Resolution:		Disposition:	;	QA:	N/C Close	d:	_ Date: _	

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		Description of NC	Corrective Action				Verification	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion	Sign & Date	Section C	Chief Eng	QC Inspector				
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			·										

THS. D3211-1 BRACKET , DOCUMENT MACHINE PER DRAWING FILE "D3211-A2.DWG" CHECK PER TEMPLATE D3211-1T1 MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 Ö POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
USE MINIMUM BEND RADIUS OF 0.188", EXCEPT WHERE INDICATED 0.125 2508 Copyright © 2003 by DART AEROSPACE LTD
PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 1.00 0 (TYP) 0 o 0 03.09.03 9.50 0 0 03.12.05 03.09.03 ٥ o 0 D3211 DRAWING NO. BRACKET RO.125 BEND RADIUS (TYP) 4 SAFE NEW ISSUE 15.89 2 RT AEROSPACE L S. S. E P 1.00 (REF) noto: ANY PURPOSE 9 SHOP COPY **RETURN TO** 03 H SHEET **ENGINEERING** 3 **UNCONTROLLED COPY** COPIED SUBJECT TO AMENDMENT SCALE Q WITHOUS ...
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Dart Aerospace Li

W/O:			WORK ORDER CHANGES							
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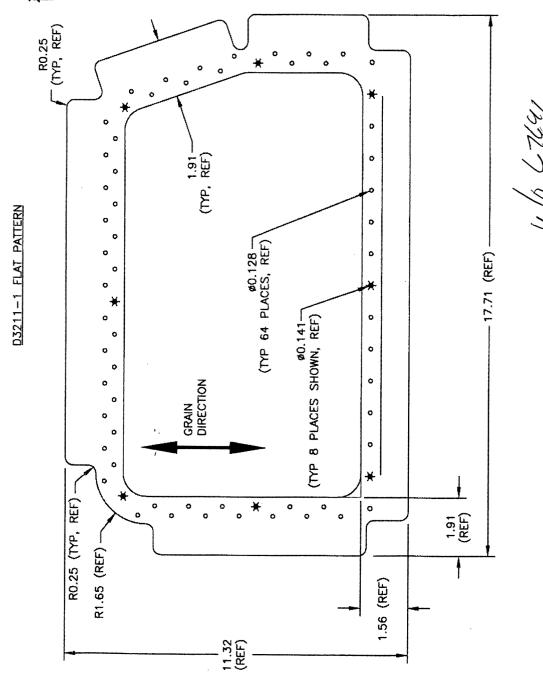
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	03.09.03		BRACKET	1:3

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Dart Aerospace L	_td
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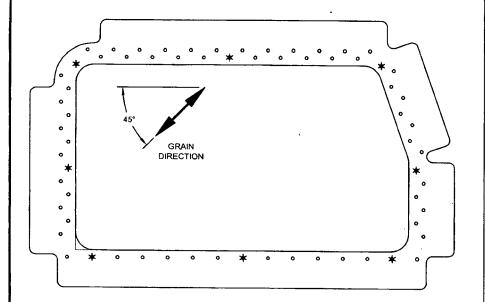
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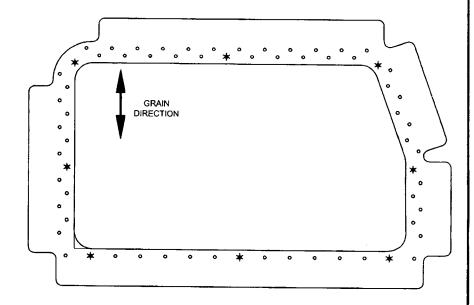
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SHEET 2 MODIFY GRAIN DIRECTION AS SHOWN BELOW TO FACILITATE BENDING (SEE CAR 08-001).

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ALL OTHER INFORMATION REMAINS UNCHANGED

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W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	CEDURE	DURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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